

## Micro-Tuflok

Product

## M300125-08

Part Number

## Pull Out Testing

Specifications

- Objective:** To determine the force required to pull a resistor, held by a Micro-Tuflok (P/N M30-0125-08), off of a PC Board, before and after wave soldering.
- Equipment:** Tinius Olsen 5000 equipt with 5000 lbf transducer.
- Setup:** The component leads are cut so that they will not be a factor. A two inch machinist clamp is attached to the component directly above the Micro-Tuflok. The PC Board is then placed on a block while the clamp slides onto a hook on the Tinius Olsen. The PC Board is secured to the block.
- Procedure:** Once the setup described above is complete tension force is applied at a rate of 1.50 in./min. The peak force and the conditions at which the peak force was encountered are recorded.
- Conclusion:** The data as listed below determines that the pull out force of the Micro-Tuflok is approximately 50 to 60 lbs. and does not degrade after exposure to the wave soldering process.

**Data:**

*Micro-Tufloks not wave soldered.*

Board 1	53 lbs.	Component broke
Board 2	54 lbs.	Clamp released (board retested)
	56 lbs.	Micro-Tuflok pulled out

*Micro-Tufloks wave soldered twice.*

Board 1	60 lbs.	Micro-Tuflok pulled out
Board 2	50 lbs.	Clamp released
Board 3	45 lbs.	Part bent up then clamp released
Board 4	43 lbs.	Clamp released part retested
	44 lbs.	Component broke
Board 5	46 lbs.	Clamp released part retested
	49 lbs.	Micro-Tuflok pulled out
Board 6	60 lbs.	Micro-Tuflok pulled out